Work Order II Thursday, May 26, 20		1								1.		Page 1
Item ID: D324 Revision ID: Item Name: Door Start Date: 5/26/	/2011 <b>Start (</b>	Qty: 6.00	` `		Accept	Cust Iter	m ID:		s s	Setup Star Stop	1 10011191 0	1414   11   11   11   11   11   11   11
Required Date: 6/3/2 Reference: Approvals: Pro QC	cess Plan:	Qty: 6.00	Date: ,	<b>          </b>   -05-20	Tooling: SPC (Y/N):	Custome	Date:		F	Run Star Stop		
Sequence ID/ Work Center ID	Operat Descrip				Set Up/ Run Hours	Tool II		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3245	Revision Nb Rev B	or '			,		- 1			• • • • • • • • • • • • • • • • • • • •		
Waterjet FLOW CNC Waterjet	FLOW V	VATER JET  Memo  1-Cut as per  Deburr if ne	r Dwg D3245 ecessary	5 □Dwg Rev	0.00 0.00 :_ <b>Q</b> □Prog Rev:	<u>B</u> □2-			185(	( <del>-6-</del> (3	<u>(9)</u>	
QC Quality Control	QC2- Ins	spect parts off n Memo	nachine FAI/	FAIB	0.00 				े (ह)	1-6-12	. —	
120 	QC8- ln	spect parts - sec	ond check		v S 00.0	lo6/14	<b>\$</b> .		48		·	

Memo

Quality Control

Dart Aerospace I	Ltd
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W/O:			W	ORK ORDER CH	IANGES	<del></del>		_		
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	N	ICR: Yes	No DQA	<b>\</b> :	Date:	
	R	esolution:	Dispositi	on:	c	A: N/C Clo	sed:		Date: _	
NCR:			WORK ORI	DER NON-CONFO	RMANO	CE (NCR	)			
DATE	STEP	Description of NC		Section B		Verific		Approval	Approval	
	O.E.	Section A	Initial Action Descr Chief Eng Chief Eng				Section	on C	Chief Eng	QC Inspector

Stop	Work Ord Thursday, May									Page
Start Date: 5/26/2011 Start Qty: 6.00  Required Date: 6/3/2011 Req'd Qty: 6.00  Cust Item ID: Customer:  Reference:  Approvals: Process Plan: Date: Tooling: Date: SPC (Y/N): Date: Stop  QC: Date: SPC (Y/N): Date: Sequence ID/ Work Center ID Description  Run Start William Stop  Stop  Stop  William Accept Reject Reject Ins Run Hours  0.00  NC Brake  Brake NC Memo  Deburr if necessary, buff entire surface to ensure a nice surface finish. DForm  Description  Cust Item ID: Customer:  Run Start William Start  Run Start William Start  One Stop  Number Start  One Start William Start  One Start Wil	Revision ID:			Accept				Setup		 
Approvals: Process Plan: Date: Tooling: Date: Stop	Start Date: Required Date	5/26/2011			D:				зюр	<b> </b>
Work Center ID  Description  Run Hours  0.00  NC BRAKE  Brake NC  Memo  Deburr if necessary, buff entire surface to ensure a nice surface finish.   Form	Approvals:		an:		 -			Run		
	Work Center I  130  Brake NC	D	Description  NC BRAKE  Memo  Deburr if ne	Run Hours 0.00 0.00 e to ensure a nice surface	. 1	Code	Qty			Insp. Stamp

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

150

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

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Page 2

## **Dart Aerospace Ltd**

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W/O:			V	ORK ORDER CH	IANGES					
DATE	STEP	PROC	EDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	·	PAR #:	_ Fault Ca	tegory:	NC	R: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
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NCR:		W	ORK OR	DER NON-CONF	ORMANC	E (NCR	1)		•	ļ
DATE	STEP	Description of NC	Initial	Corrective Action Action Descri	Section B	Sign &		cation	Approval	Approval
·		Section A	Chief Eng	Chief Eng		Date	Secti	ion C	Chief Eng	QC Inspector
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NOTE: D	ate & initi	al all entries		,	1		· · · · · · · · · · · · · · · · · · ·			

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Work	O	rder	ID	70	በደበ
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Thursday, May 26, 2011 11:33:53 AM



Page 3

Item ID:

D3245-3

Accept

Setup Start

**Revision ID:** 

**Start Date:** 

Item Name:

Door

Required Date: 6/3/2011

5/26/2011

Start Qty: 6.00

Req'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

**Process Plan:** 

QC:

Operation

Description

QC21- Final Inspection - Work Order Release

Date: Date:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop



Sequence ID/

Work Center ID

QC Quality Control

**Run Hours** 

Set Up/

**Tooling:** 

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject Qty

Reject Number

Insp. Stamp

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0.00

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W/O:			N	ORK ORDER CH	ANGES					
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DATE	STEP	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
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## **Picklist Print**

Thursday, May 26, 2011 11:33:58 AM

Work Order ID: 70080

Parent Item:

D3245-3

Parent Item Name: Door

Start Date: 5/26/2011

Required Date: 6/3/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A□04.07.07□New issue□KJ/JLM□

IPP Rev:B Now on Waterjet 07-09-14 JLM Verified By:EC

IPP Rev:c ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA	BIII ABBII 184 1861	Purchased	No		100	sf	72.5000	0.537	3.391579	, S,		
										311-6-	13	

304/316 .032 Sheet

Location		Loc Qty	Loc Code		
020		7			$\sim$
	109057	7			10
MAT020		65.5			$(\Gamma)$
	117379	65.5		117379	

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W/O:			W	ORK ORDER C	IANGES	•				
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Part No	<u> </u>	PAR #:	Fault Cate	gory:	NC	R: Yes	No DQ	A:	Date: _	
		esolution:								
NCR:			WORK ORDER NON-CONF				1)			-
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Desc				Verific Secti		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date	000.1		C.mor Ling	
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DART AEROSPACE LTD	Work Order: \$70080	7
Description: Door	Part Number: D3245-3	
4		
Inspection Dwg: D3245 Rev: B	Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.219	+0.005/-0.001	.219	y		V BOZ	
0.859	+/-0.010	,860	7		V	
2.609 *	+/-0.010	2,63	>		V	
3.500	+/-0.010	3,506	>		V	
8.718	+/-0.010	8.772	7		PROUJOZ	
2.609	+/-0.010	2.615	K		V	
3.500	+/-0.010	3.50(	×		V	
8.718	+/-0.010	8,773	~		P	
1.220	+/-0.010	1.720	8		V	
0.032	+/-0.010	,छ।	<b>১</b>		1/	
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		12 T				
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****						
Measured by:	В	Audited by:			Prototype Approv	val: N/A
	11-6-13	Date: 11/06/14			Da	ate: N/A
Rev Date A 08.09.04	Change New Issue				Revise KJ/DD	ed by Approved

Dart	Aero	space	e Ltd

W/O:				WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE	E CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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										·		
Part No:P		•	:	auli Category: NC			NCR: Yes No DQA: Date:					
Resolution: Disp			Dispo	osition:								
NCR:			WORK O	RDER NON-	CONFORMANC	E (NCF	<b>?</b> )					
DATE	STEP	Description of NC		Corrective Action Section B			Verification			Approval		
	J.E.	Section A	Initial Chief En		on Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector		
	_											

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RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT -WITHOUT NOTICE WORK ORDER NO. <u>10080</u> R0.25 Ø0.219 (TYP) (TYP) MI-05-26 0.42 D (TYP) 0.859 (TYP) ė R0.09 (TYP) 2 609 · **.** À · 🕁 · 8.718 3.500 ٠Ò٠ ė Φ. ·è (TYP) 8.00 (TYP) 1,220 (TYP) 8.718 **D3245-3 DOOR BENDING DETAIL D3245-3F DOOR FLAT PATTERN** NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA) DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A D3245 MFG. APPR SHEET 5 OF 7 APPROVED TITLE SCALE ACCESS PANEL ASSEMBLY DE APPR. COPYRIGHT © 2004 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND COMPONENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION OF DE USED FOR ANY PURPOSE OR COPIED ON COMMUNICATION TO ANY OTHER DESCRIPTIONS. DATE 07.10.02 7) WEIGHT: 0.67 lbs

SHOP COPY

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W/O: WORK ORDER CHA					IANGES					
DATE	STEP	PRO		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Cate	gory:	NO	CR: Yes I	No DQA	\:	Date:	
Resolution:			Disposition	QA: N/C Closed:				Date:		
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Description Chief Eng	Section B ption	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
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